

**Work Order ID 116612**

Tuesday, April 22, 2014 11:36:43 AM

**\*116612\***

Page 1

Item ID: D5046-5

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Co-Pilot Collective Head

Start Date: 4/23/14 Start Qty: 5.00 **\*5\***

Cust Item ID:

Required Date: 4/30/14 Req'd Qty: 5.00 **\*5\***

Customer:

Reference:

Approvals:

Process Plan: 

Date: 14-04-22 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D5046

A

100

Cut blanks as per folio

0.00

**\*100\***

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK AT 5.500"

0.00

5

Ø

DAS  
44  
9-89

14/04/22

110

0.00

**\*110\***

HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER DWG &amp; FOLIO FB296/ D5046-5

FOLIO REV: AADWG REV: A

0.00

5

Ø

DAS  
08  
9-89

B.A 14/04/24

\*\*\*DO NOT BUFF OR POLISH PART\*\*\*

DEBURR

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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*Tuesday, April 22, 2014 11:36:43 AM*

Page 2

MH 14/54/26

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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# Picklist Print

Tuesday, April 22, 2014 11:36:48 AM

Page 1

Work Order ID: 116612

**\*116612\***

Parent Item: D5046-5

**\*D5046-5\***

Parent Item Name: Co-Pilot Collective Head

Start Date: 4/23/14

Required Date: 4/30/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV.A NEW ISSUE JFS 14/04/22 VERIFIED BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X05.00 0		Purchased	No			100	f	9.5000	0.459	3			

**\*M6061T6B2 000X05 000\***

**\*\***

6061T6 Bar 2.00 x 5.000

Location

Loc Qty

Loc Code

MAT

9.5

m128866

9.5

3'

DAS  
44  
9-89

14/04/22

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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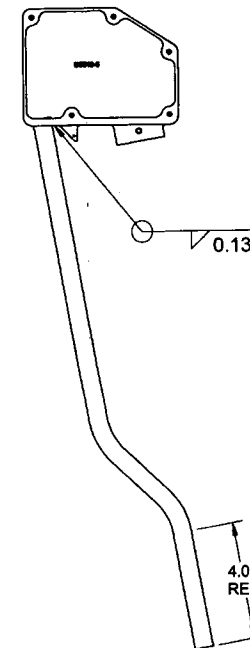
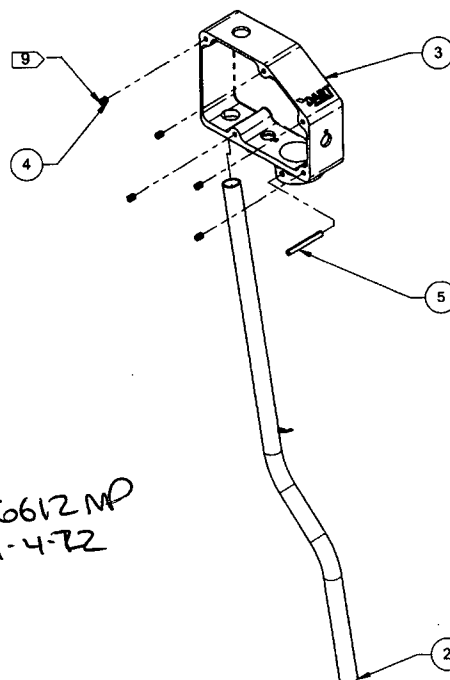
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

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ITEM	QTY	P/N	DESCRIPTION
1	X	D5046-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
2	1	D4410-7	CONDUIT
3	1	D5046-5	CO-PILOT COLLECTIVE HEAD
4	5	90296A108	HELI-COIL INSERT (6-32 X 0.276)
5	1	MS171599	PIN



**D5046-045 WELDING DETAIL**

**D5046-045 CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)**

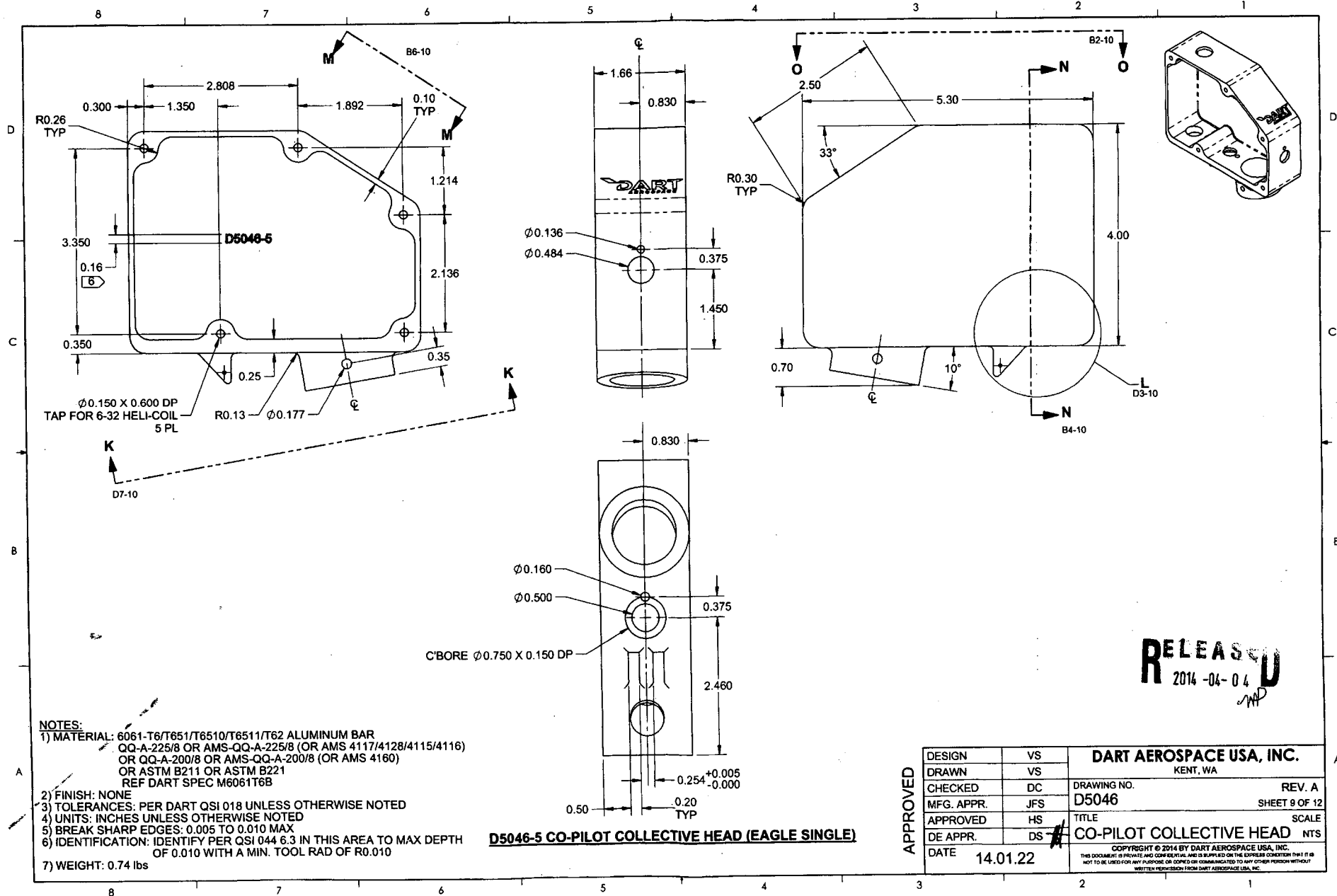
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.90 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

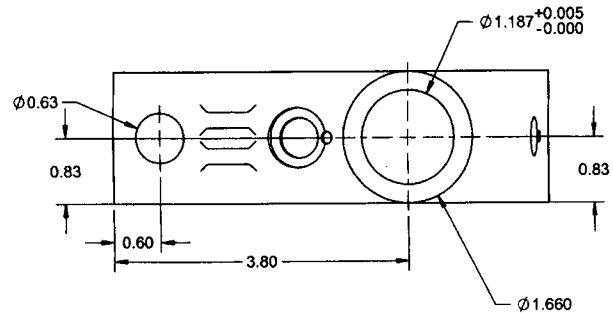
APPROVED

DESIGN	VS	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	VS	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JFS	<b>D5046</b>	SHEET 3 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>CO-PILOT COLLECTIVE HEAD</b>	NTS
DATE	14.01.22	<small>COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

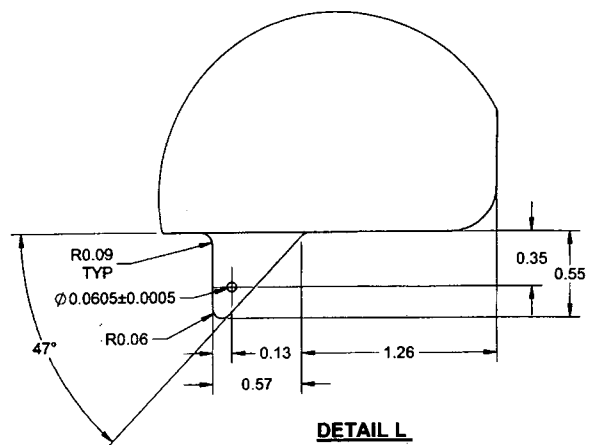
**RELEASED**  
2014-04-06



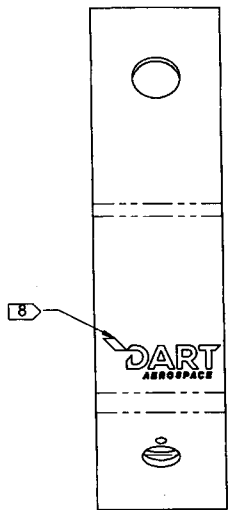
8 7 6 5 4 3 2 1



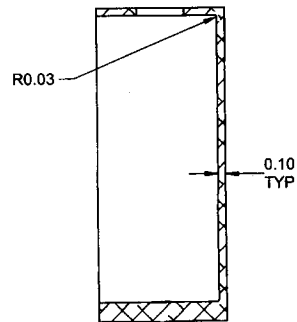
**VIEW K-K**  
B7-9



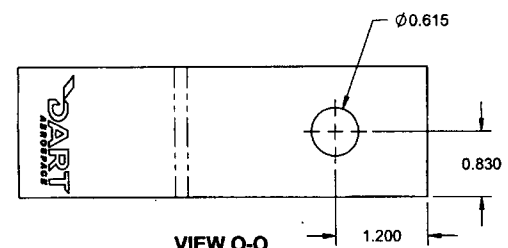
**DETAIL L**  
C2-9



**VIEW M-M**  
D6-9



**SECTION N-N**  
C2-9



**VIEW O-O**  
D3-9

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.74 lbs
  - 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP

**D5046-5 CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)**  
**DETAIL VIEWS**

APPROVED

DESIGN	VS	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	VS	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JFS	<b>D5046</b>	SHEET 10 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>CO-PILOT COLLECTIVE HEAD</b>	NTS
DATE	14.01.22	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

**RELEASED**  
2014-04-04

8 7 6 5 4 3 2 1

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	116612
<b>Description:</b> CO-PILOT COLLECTIVE HEAD	<b>Part Number:</b>	D5046-5
<b>Inspection Dwg:</b> D5046 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.830	+/- .010	0.831	✓		H-6	31006
φ 0.160	+ .005 / - .001	φ 0.161	✓		Vern	6A-01
φ 0.500	+ .006 / - .001	φ 0.501	✓		"	"
0.375	+/- .005	0.375	✓		H-6	31006.
φ 0.750 x 0.150	+ .008 / - .001 / +/- .010	φ 0.751 x 0.151	✓		Vern	6A-01
2.460	+/- .010	2.460	✓		H-6	31006
0.254	+ .005 / - .000	0.255	✓		Vern	6A-01
0.20	+/- .030	0.198	✓		"	"
0.50	+/- .030	0.502	✓		D-6	6A-08
φ 0.63	+ .030 / - .030	φ 0.627	✓		Vern	6A-01
φ 1.187	+ .005 / - 0.000	φ 1.189	✓		"	"
φ 1.660	+/- .010	φ 1.658	✓		Mic	6A-02
R 0.09	+/- .030	R 0.088	✓		R-6	ref.
φ 0.0605	+/- .0005	φ 0.0605	✓		Mic / 6-P	6A-03 / ref
R 0.06	+/- .030	R 0.063	✓		R-6	ref.
0.13	+/- .030	0.125	✓		H-6	31006
0.35	+/- .030	0.350	✓		"	"
0.55	+/- .030	0.551	✓		"	"
R 0.03	+/- .030	R 0.030	✓		R-6	ref.
0.10	+/- .030	0.101	✓		Mic	6A-02
φ 0.615	+ .008 / - .001	φ 0.6155	✓		Vern	6A-01
0.830	+/- .010	0.830	✓		H-6	31006
1.200	+/- .010	1.201	✓		"	"

<b>Measured by:</b> B.A.	<b>Audited by:</b> DAS 44 9-89	<b>Preliminary Approval:</b>
<b>Date:</b> 14/04/24	<b>Date:</b> 14/04/27	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 116612
<b>Description:</b> CO-PILOT COLLECTIVE HEAD	<b>Part Number:</b> D5046-5
<b>Inspection Dwg:</b> D5046 Rev: A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.892	+/- .005	1.893	✓		H-6	31006
2.808	+/- .005	2.808	✓		"	"
1.350	+/- .005	1.350	✓		"	"
0.300	+/- .010	0.301	✓		"	"
3.350	+/- .005	3.350	✓		"	"
0.350	+/- .010	0.349	✓		"	"
φ0.150 x 0.600	+0.005/-0.001 / +/- .010	φ0.151 x 0.608	✓		Vern	GA-01
0.25	+/- .030	0.250	✓		Mic	GA-03
R0.13	+/- .030	R0.125	✓		R-6	REF.
φ0.177	+0.005 / -0.001	φ0.178	✓		Vern	GA-01
0.35	+/- .030	0.347	✓		"	"
2.136	+/- .005	2.136	✓		H-6	31006
1.214	+/- .005	1.214	✓		"	"
1.66	+/- .030	1.658	✓		Vern	GA-01
0.830	+/- .010	.830	✓		"	"
φ0.136	+0.005 / -0.001	.137	✓		MH-04	Caliper
φ0.484	+0.006 / -0.001	.486	✓			
0.375	+/- .010	.375	✓			
1.450	+/- .010	.452	✓			
5.30	+/- .030	5.300	✓		Vern	CNC-02
4.00	+/- .030	3.997	✓		"	"
10°	+/- 1/2°	10°	✓		Angle M.	CNC-12
0.70	+/- .030	0.695	✓		H-6	31006

DAS

<b>Measured by:</b> A.A. MH DAS 08	<b>Audited by:</b> 44 9-89	<b>Preliminary Approval:</b>
<b>Date:</b> 14/04/24 9-89	<b>Date:</b> 14/04/27	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15